

Work Order ID 44759

June 26, 2009 10:53:07 AM



Item ID: D3709-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *09/09/24* Tooling: *✓*

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3709	Rev A
-------	-------

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 □ Dwg Rev: □ LiProg Rev: □

□

****grain direction on a 45 degree **** 112- Deburr if necessary

SKP

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Work Order ID 44759

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Page 2

Item ID: D3709-1

Accept

Revision ID: A

Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3709

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Scrap

W 9.10.30

Work Order ID 44759

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Page 3

Item ID: D3709-1

Accept

Revision ID: A

Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00




Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Picklist Print

June 26, 2009 10:53:06 AM

Page 1

Work Order ID: 44759

Parent Item: D3709-1RevA

Parent Item Name: Angle


Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	0.0000	0.2800			
												
6061-T6 .063 Sheet												

Date: Wednesday, 14/01/2009 3:23:17 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001. Dart Helicopters Services Drawing Name : ANGLE
 Job Number : 44759
 Estimate Number : 13639
 P.O. Number :
 This Issue : 14/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 05065
 Part Number : D37091
 Drawing Number : D3709 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 16/01/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF 09-01-14
 Comment : Est Rev:A 08-10-31 new issue DD verified by:EC



Additional Product

PRELIMINARY ISSUE

Job Number:


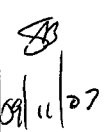
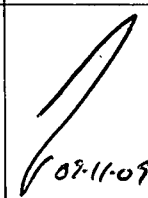
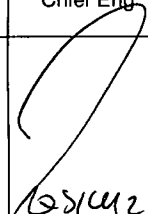
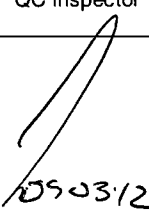

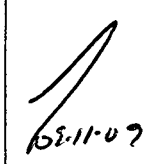
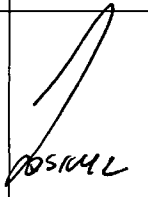
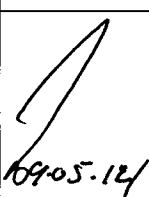


09.01.14 for ECN# 09.02.502P

Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S063 	6061-T6 .063 Sheet
Comment: Qty.: 0.2855 sf(s)/Unit Total: 0.2855 sf(s) 6061T6 aluminium sheet .063" thick (M6061T6S063) Batch: <u>100551</u> HB 9-3-12		
2.0	WATER JET 	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3709 Dwg Rev: <u>PR5</u> HB 9-3-12 Prog Rev: <u>2: M</u> ****grain direction on a 45 degree **** 2- Debur if necessary HB 9-3-12		
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 9-3-12		
4.0	QC8 	SECOND CHECK
Comment: SECOND CHECK HB 9-3-12 (3) ENGINEERING APPROVAL (P70)		
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
Comment: Form as per dwg D3709 see P70 to sign please.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3709-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 05.11.11
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 44759		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0503/12	4.0	1 part scrap, it has a 0.024" deep by 0.190" long, due to a blow out from the w.s. R.C: Process		Use as a sample piece to experiment the bend form. Then scrap & destroy. No replace.	 09/11/07	 07.11.09	 05/11/12	 0903/12
09/04/14		3 parts scrap 2 parts crack 1 was out of tolerance Change radius die	 05/11/12	Scrap & destroy	09/11/03	 05.11.09	 05/11/12	 0905.12/
		to .060 to .093 : Part dims. R.C: New design.						

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 44759

Part Number: D37091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



**ENGINEERING
APPROVAL**



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.05 AUTH _____

RELEASED _____ DATE _____

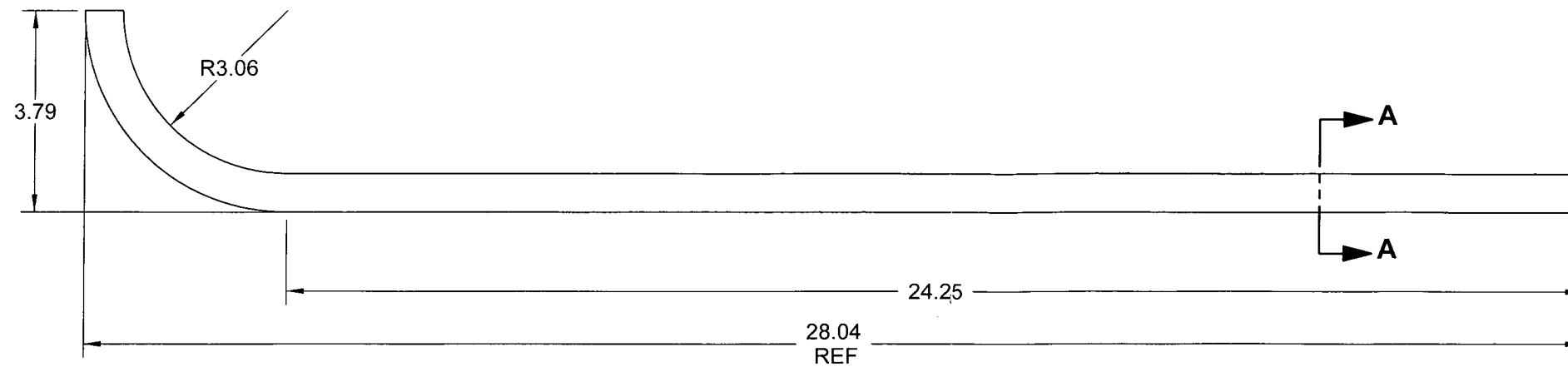
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

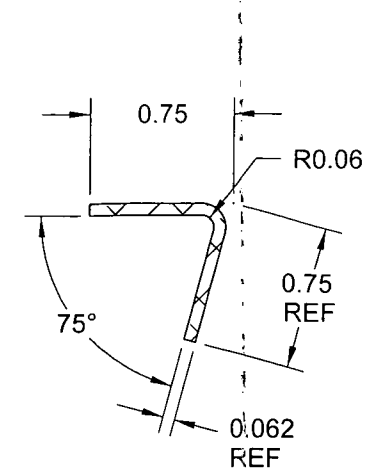
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

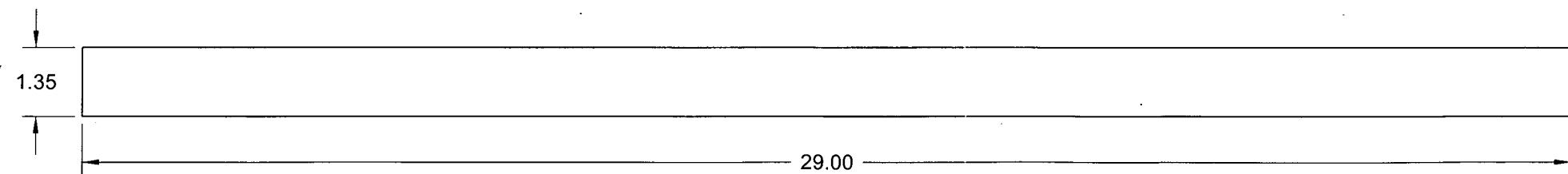
NOTE: Date & initial all entries



D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X



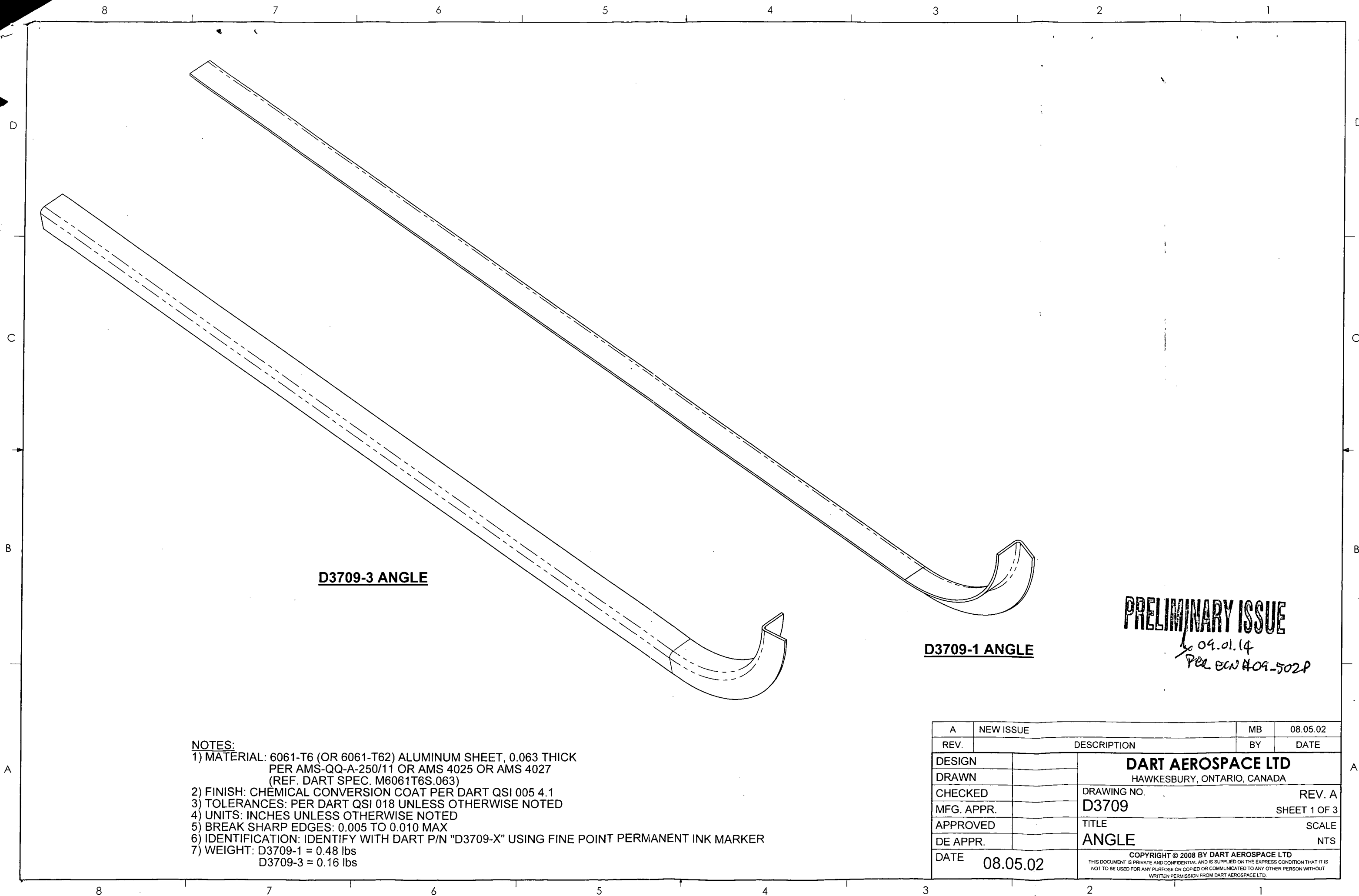
D3709-1F ANGLE FLAT PATTERN

PRELIMINARY ISSUE

2009.01.14 PBR
ECW 09-502P

0.063" thick material
F

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
DATE	08.05.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3709-3 ANGLE

D3709-1 ANGLE

PRELIMINARY ISSUE
09.01.14
PER ECN #409-502P

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.48 lbs
D3709-3 = 0.16 lbs

A	NEW ISSUE		MB	08.05.02
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3709	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		ANGLE	NTS	
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